

# Work Order ID 74604

Monday, October 03, 2011 4:02:14 PM

Page 1

Item ID: D2933-2

Accept

Revision ID:

Item Name: Saddle RH In, 206

Start Date: 10/3/2011 Start Qty: 6.00

Required Date: 10/5/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date: 11-10-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2933

Rev C

100

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC

QC1- Inspect dimensions to dimension sheet

Memo

0.00

Quality Control

ASAP

B.A 12/03/11

B.A 12/03/11

B.A 12/03/11

6 0

6 0

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74604**

Page 2

Monday, October 03, 2011 4:02:14 PM

Item ID: D2933-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH In, 206

Start Date: 10/3/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mf 12/03/13

6 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6xpm 12/03/13

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10h55  
10h25

OVEN TEMPERATURE:

320°F

m120222

6 0 (DPH) 12/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74604**

Monday, October 03, 2011 4:02:14 PM

Page 3

Item ID: D2933-2

Accept

Revision ID:

Item Name: Saddle RH In, 206

Start Date: 10/3/2011 Start Qty: 6.00

Required Date: 10/5/2011 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 12-3-14

170

Identify as per dwg &amp; Stock Location ST 428

0.00



Packaging

Memo

0.00

Packaging

6x SP12-03-14

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/3/15

012-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, October 03, 2011 4:02:18 PM

Page 1

Work Order ID: 74604



Parent Item: D2933-2



Parent Item Name: Saddle RH In, 206


Start Date: 10/3/2011

Required Date: 10/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC□  
IPP Rev:C As per Rev C 07-03-19 JLM □

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	4.0000	1	6			

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

4

66965

1

69677

2

73768

1

79586

6

FK 12/03/09.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 74604
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b> D29332
<b>Inspection Dwg:</b> D2933 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By 5	Date 6
A	0.100	0.140		0.129	0.129	0.129	0.129	0.128	0.129
B	0.100	0.140		0.130	0.130	0.130	0.130	0.130	0.130
C	0.100	0.140		0.117	0.117	0.118	0.117	0.117	0.117
D	0.210	0.230		0.223	0.223	0.223	0.223	0.223	0.223
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		0.512	0.512	0.512	0.512	0.512	0.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		0.260	0.260	0.260	0.260	0.260	0.260
L	0.312	0.317		0.314	0.314	0.314	0.314	0.314	0.314
M	0.235	0.240		0.237	0.237	0.237	0.237	0.237	0.237
N	0.100	0.140		0.124	0.124	0.124	0.124	0.124	0.124
O	0.540	0.560		0.550	0.550	0.550	0.550	0.550	0.550
P	0.490	0.510		0.500	0.497	0.498	0.500	0.498	0.499
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.490
S	0.240	0.270		0.254	0.254	0.254	0.254	0.254	0.254
T	0.100	0.180		0.135	0.135	0.135	0.135	0.135	0.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		0.316	0.316	0.316	0.316	0.316	0.316
X	1.125	1.145		1.135	1.135	1.135	1.135	1.135	1.135
Y	1.565	1.585	DT8695 A/B	1.574	1.574	1.574	1.574	1.574	1.574
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188	0.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DA
Date: 12/03/11

Audited by: [Signature]
Date: 12/03/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

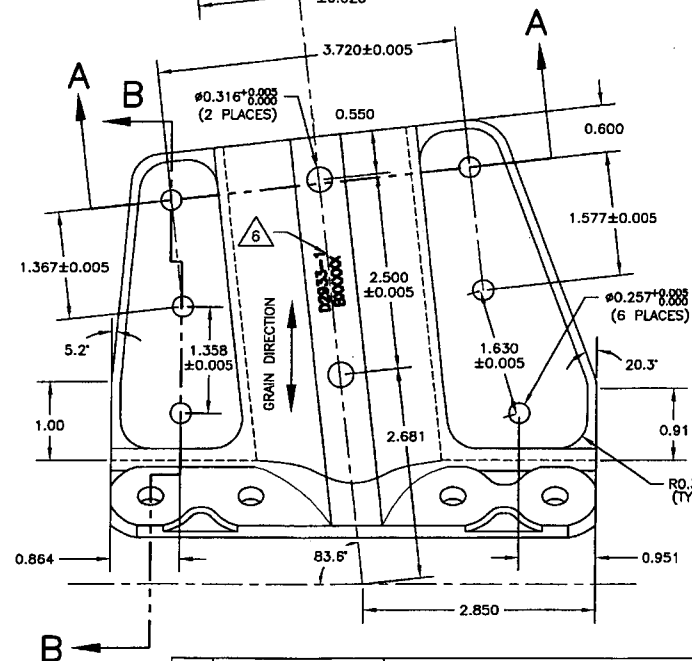
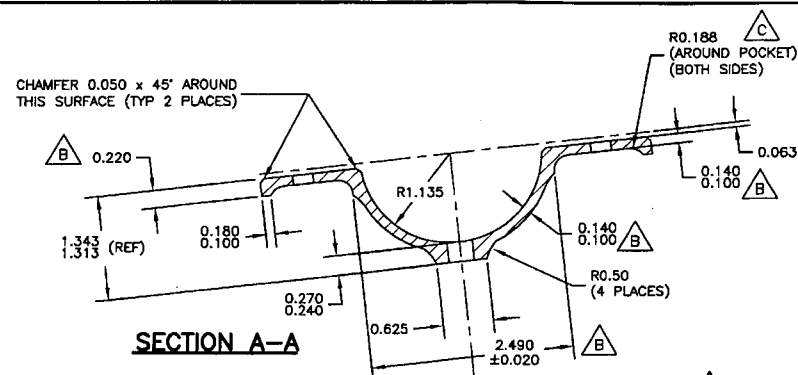
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**NOTE:** Date & initial all entries



**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D8101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY CB	<b>DART</b> DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2933
DATE 06.11.09		TITLE SADDLE INSIDE
		REV. 0 SHEET 1 OF 2

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DART AEROSPACE USA, INC.

**DART** DART AEROSPACE USA, INC.  
BELLINGHAM, WA

DRAWING NO.	REV. (
D2933	SHEET 1 OF

TITLE	SCALE
SADDLE INSIDE	2:3

07.02.12

07.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries